

Date: Thursday, 05/02/2009 3:46:16 PM
 User: Julie Dawson

Process Sheet

| | | | | | | | |
|-----------------------|--|--|--|------------------|--------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : STEP (CASTING DETAIL) | | |
| Job Number | : 45553 | | | Part Number | : D25761 | | |
| Estimate Number | : 11088 | | | Drawing Number | : D2576 REV G | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 05/02/2009 S.O. No. : | | | Drawing Revision | : G | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / Type : PURCHASED PARTS | | | Due Date | : 20/02/2009 Qty: 100 Um: Each | | |
| Previous Run | : 43534 | | | | | | |
| Written By | : | | | | | | |
| Checked & Approved By | : <u>JUL090206</u> | | | | | | |
| Comment | : Est Rev: A New Issue 05-11-29 JLM est rev B rev F dwg 07.07.06 EC Est Rev:C As per Rev G 07-09-05 JLM Verified By:EC | | | | | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--|
| Seq. #: | Machine Or Operation: | Description : |
| 1.0 | PG | PURCHASING |
| | | Comment: PURCHASING Issue P/O: <u>8157</u> <i>C 20/02/06</i> Ship D2576 mould to vendor Cast per D2576-1 Pattern Material Release Note Required <i>100</i> |
| 2.0 | D25761P | Step (Casting Detail) |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) STEP |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure D2576 mould is returned with the ordered parts Ensure release note is attached <i>1/2/20 (100)</i> |
| 4.0 | QC6 | DIMENSIONAL CHECK |
| | | Comment: DIMENSIONAL CHECK <i>1/2/20 (100)</i> |
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>CNC Location</u> <i>S09/02/06 (105)</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date:
User:

Thursday, 05/02/2009 3:46:17 PM
Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 45553

Part Number: D25761

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10 HJ

Job Completion



MF 09-03-09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

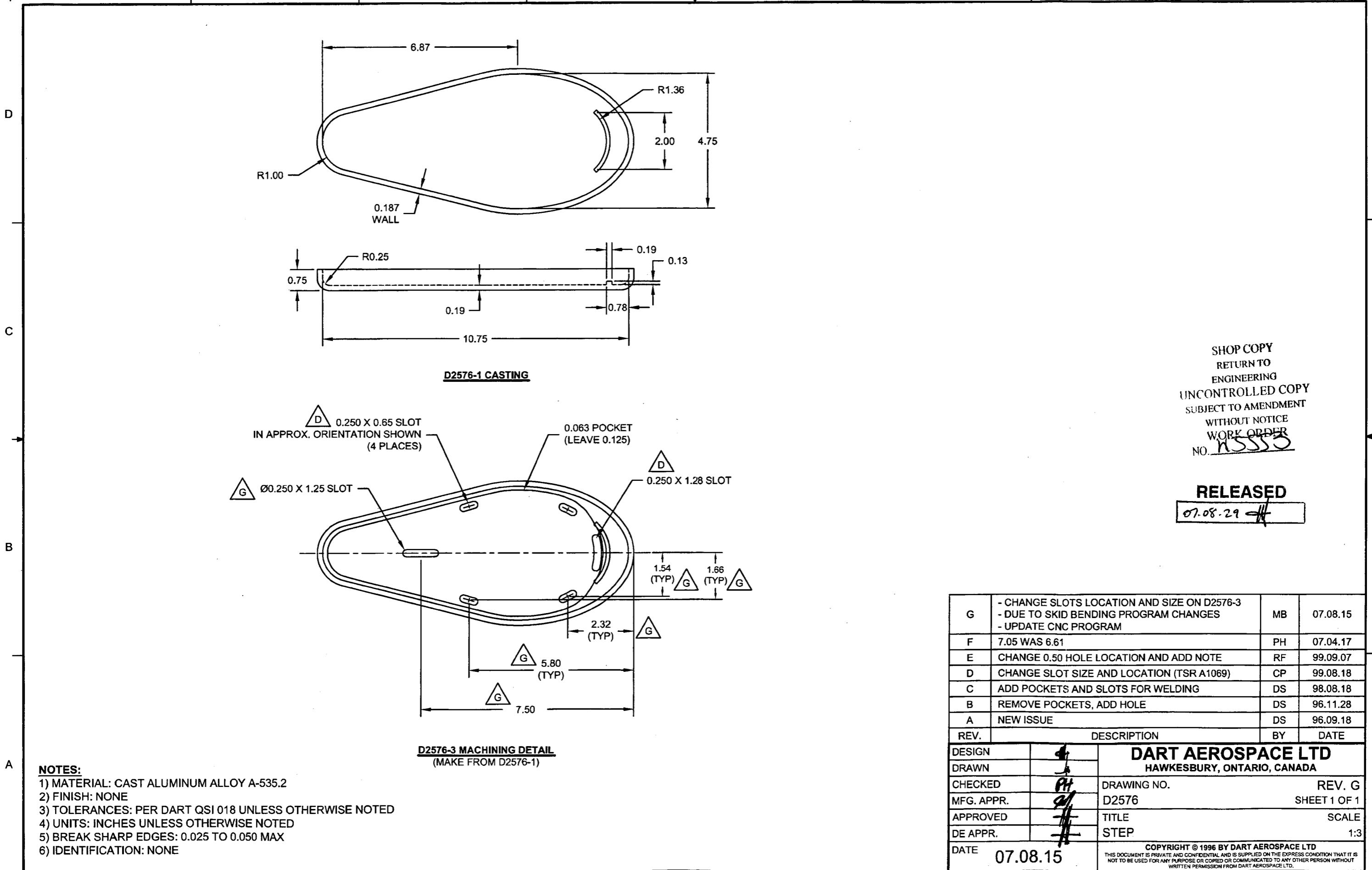
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

ALPINE NON-FERROUS FOUNDRY
8657-132ND STREET
SURREY, B.C. V3W 4P1

WORK ORDER

Tel:(604) 596-8080 Fax: (604) 596-8045

Sold To: **DART AEROSPACE**
1270 ABERDEEN STREET
HAWKESBURY, ONT K6A 1K7
CANADA

Ship To: **DART AEROSPACE**

| Order Date | | Purchase Order# | Due Date | Ship Via | | Page | |
|-------------------|------------------|------------------------|-----------------|-----------------|----------------|-------------|-----------------|
| 06-Feb-2009 | | PO0008157 | 20-Feb-2009 | FEDEX | | 1 | |
| Item# | Item Code | Description | | Material | Ordered | B/O | Qty Ship |
| 1 | DART D2576 | D2576 STEP CSTG | | | 100 | | 100 |
| 2 | | | | | | | |

Comments

Castings&Patterns are property of Alpine until paid in full

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
PH# (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

PYPAC ALUMINUM
11849 TANNERY ROAD
SURREY BRITISH COLUMBIA,

SHIP DATE

NOV 05 2008

CONFORMS TO ASTM SPECIFICATION: B179-06

S
0702/26

PPM: 535.2

Sample: a8297

| | | | |
|-----------|-------|-----|-----------|
| S | 0.075 | Si | .10 |
| P | 0.087 | Fe | .10 |
| C | 0.005 | Cu | .05 |
| Mn | 0.173 | Mn | .10-.25 |
| Al | 7.380 | Mg | 6.6-7.5 |
| Cr | 0.001 | Cr | |
| Zr | 0.050 | Zn | .05 |
| Ti | 0.146 | Ti | .10-.25 |
| Sn | 0.004 | Sn | |
| Pb | 0.001 | Pb | |
| Ni | 0.001 | Ni | |
| CF | < .15 | OET | .15 |
| Si | 0.000 | Sr | |
| REMAINDER | | Al | REMAINDER |

BE 004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

Ron Zaborski

RON ZABORSKI

MANAGER
PPM 05/2008

NOV 05 2008

DATE

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREEVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.